

Date: Friday, 28/11/2008 2:54:35 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HI-STEP LEG ASSEMBLY		
Job Number	: 43858		Part Number	: D3065041		
Estimate Number	: 10385		Drawing Number	: D3065 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	28/11/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	20/12/2008	Qty:	50
Previous Run	: 42344		Um:	Each		
Written By	:		54			
Checked & Approved By	: JUL 08.12.01					
Comment	: Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	43858A	STEP SPACER			<i>Epoxy/01/12</i>	<i>B42344A 11X</i>
						<i>B41445A 43X</i>
2.0	43858B	STEP SPACER			<i>Epoxy/01/12</i>	<i>B43858B 10X</i>
3.0	43858C	STEP LEG			<i>Epoxy/01/12</i>	<i>B43858C</i>
4.0	43858D	STEP SPACER			<i>Epoxy/01/12</i>	<i>B41445D 36X</i>
5.0	MS20470AD44	Rivet, Universal Head			<i>Epoxy/01/12</i>	<i>131X 10X</i>
Comment: Qty.: 30.0000 Each(s)/Unit Total : 1500.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch 30 MS20470AD4-4 Rivet <i>M109545 889X</i> <i>M109631</i>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 43858

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

09/01/12 54

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/12 45t

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: WA

SAD 09-01-12 54

9.0 QC21 FINAL INSPECTION/W/O RELEASE



09/01/13 45

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

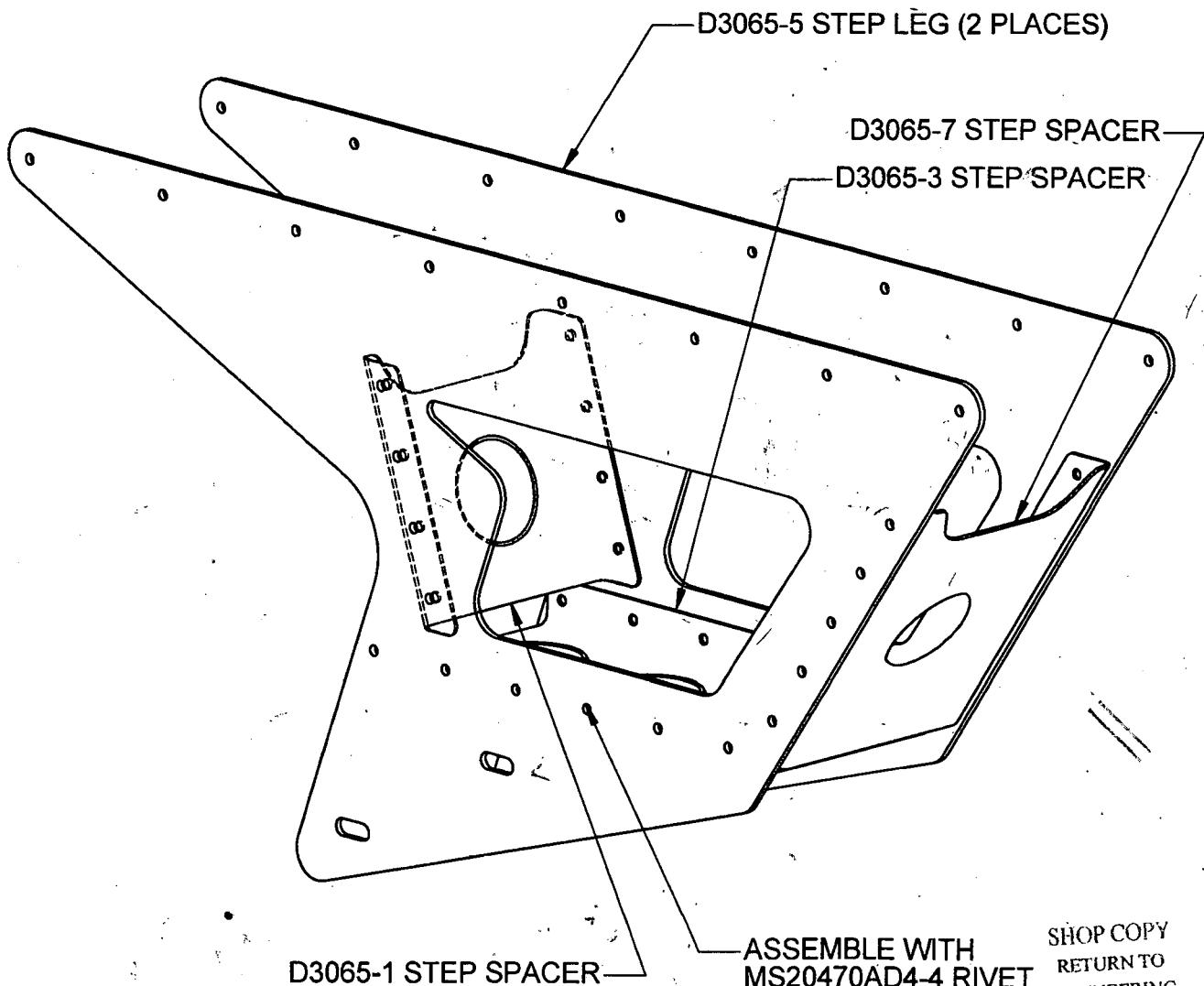
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065 REV. B SHEET 1 OF 5
DATE	06.05.23	TITLE STEP LEG ASSEMBLY SCALE 1:2

RELEASED06.06.20 *[Signature]***D3065-041 STEP LEG ASSEMBLY**

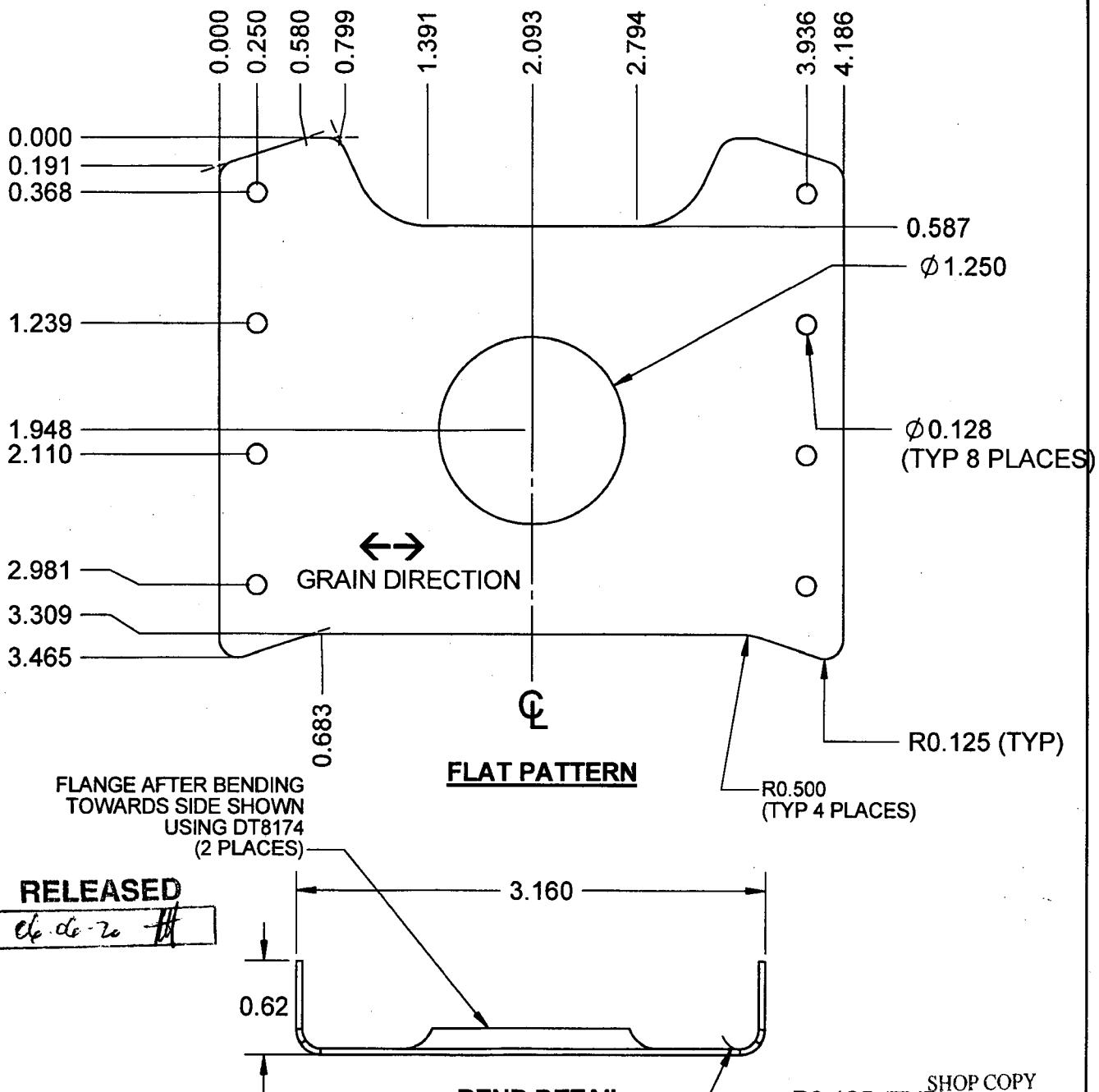
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DATE	06.05.23	REV. B SHEET 2 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

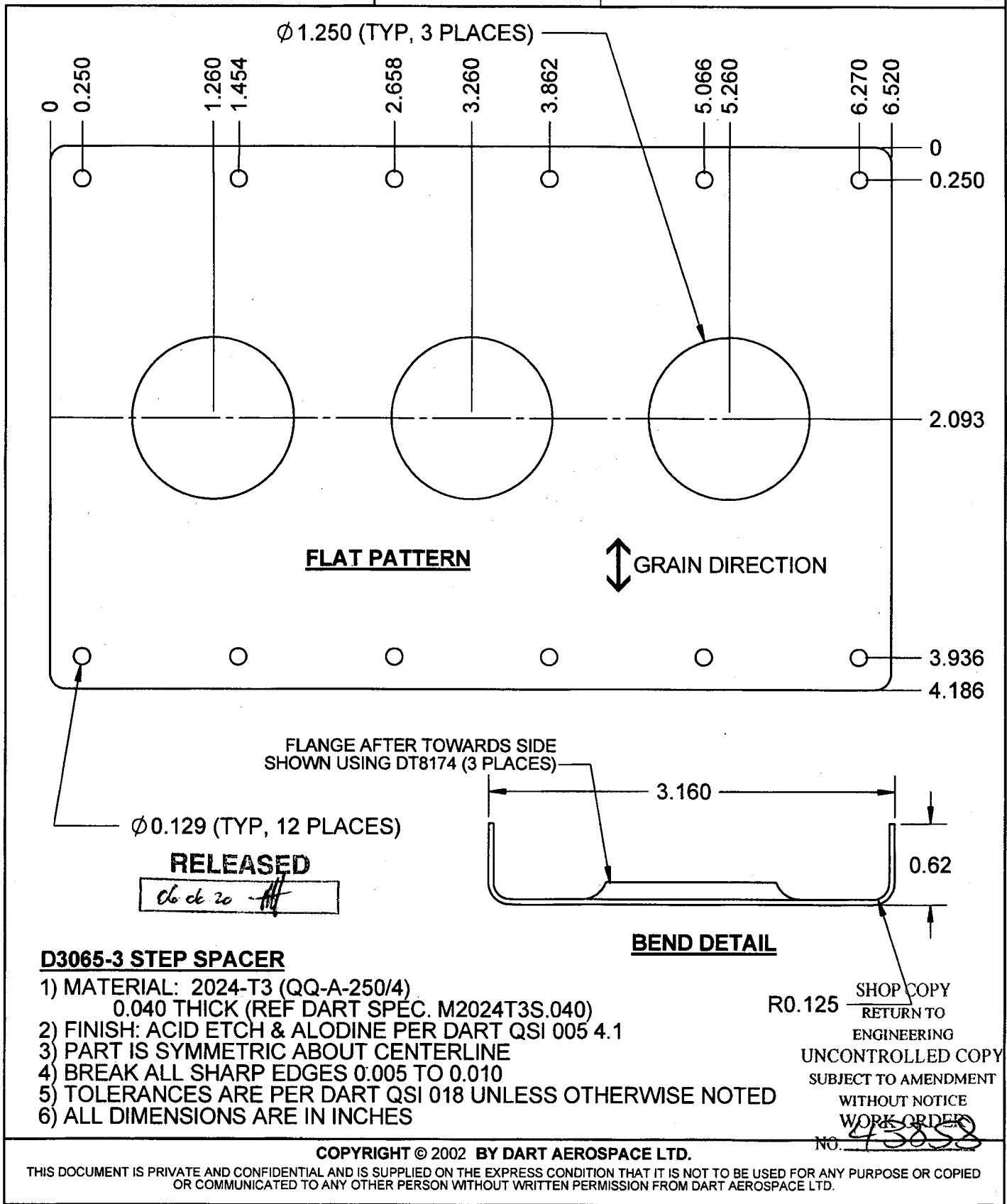
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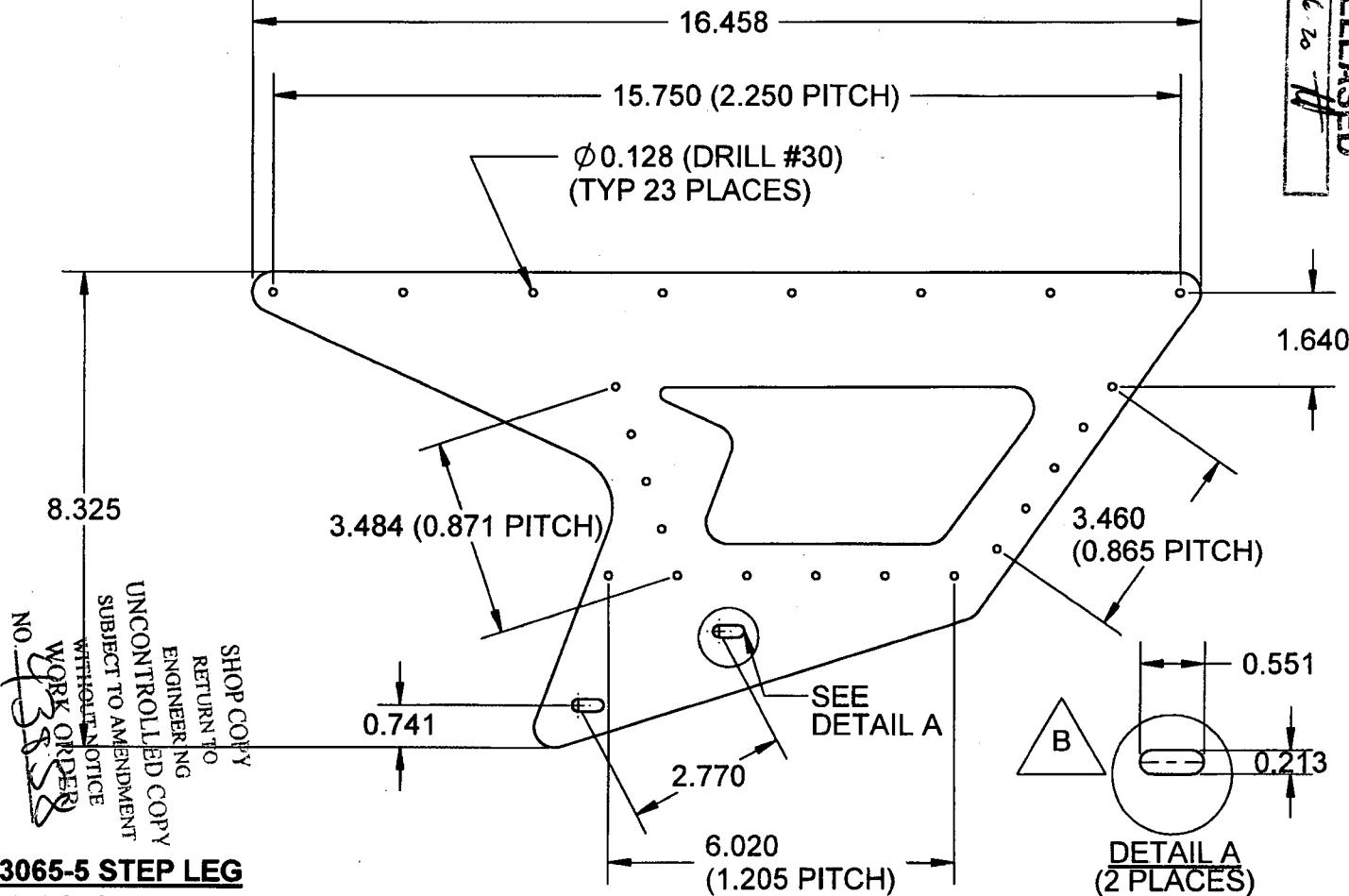
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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		



DART

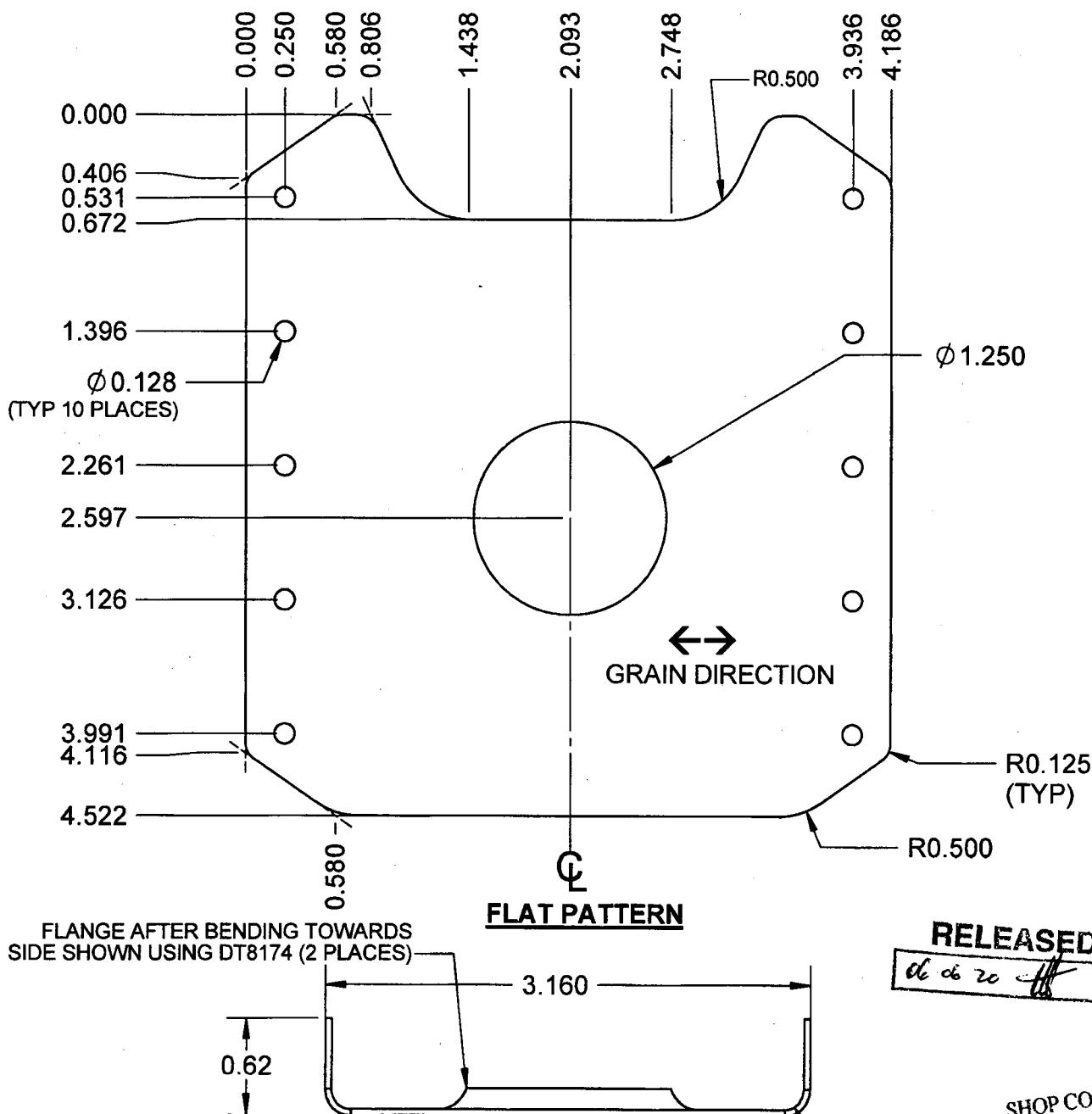
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49	C B	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3065
DATE	06.05.23	TITLE
		STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE
		1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1		



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC.)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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